5/22

DART AEROSPACE LTD	Work Order:	23156
Description: Gas Spring	Part Number:	D2807
<b>Dwg:</b> D2807 Rev. C	Qty:	25/26
		Page 1 of 1

Step	Location	Procedure	Ву	Date	Qty
1	DC	Issue Traveler	KA)	05,07,19	25
2	PG	Issue P/O: 2007997 Order as per Dwg D2807 Possible supplier: ArvinMeritor Motion Control Systems Material release note is required	W	05.06.09	25
3	RG	Receive and Inspect for transit damage  Ensure the material release note is attached	DL	05/07/19	25
4	QC6	Inspect dimensions as per Dwg D2807	88	ญ่ายไร	26
5	GA	Install lugs and crimp as per Dwg D2807  Pick:  Oty Part Number Description Description Description Description Description Description Description	Sh	05/03/15	26
6	QC5	Inspect work to Step 5	9	05/03/15	26
7	ST	Identify and Stock	SB	05/08/15	26
8	AC	Cost / part: <u>33</u> 79	R	05/08/17	26
9	DC	Close W/O 30.75 Inspect Level 21	9	05/08/16	26

Rev	Date	Change	Revised By	Approved
Α	00.11.09	New Issue	EC	
В	00.11.15	Added step 6	EC	
С	05.04.28	Reformat; Added Step 6 & 7	KJ/JLM	1
D	05.06.21	Removed painting; Changed supplier	KJ/JLM (	LM



## Dart Aerospace Ltd

W/O:		WORK ORDER CHANG	GES						
DATE	STEP	PROCEDURE CHANGE By		PROCEDURE CHANGE By	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
				y. 127		g			
	- <del></del>	**** ;			L				

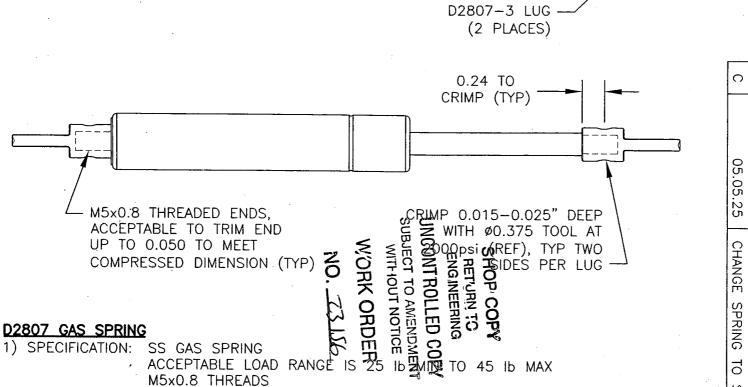
NCR:		W	ORK ORI	DER NON-CONFORMANO	CE (NCR)			
		Description of NC		Corrective Action Section B		Verification	Annroyal	Approval
DATE	STEP	Section A	Initial Design Mgr	Action Description  Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector
	-							
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Part No:	PAR #:	Fault Category:	NCR:	Yes No DQA:	Date: 05/08/17
NOTE: Date & initial all entries				QA: N/C Closed:	Date:

(Z)







ArvinMeritor Motion Control Systems, Leicester, UK

(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

6.46 MIN EXTENDED

4.88 MAX

COMPRESSED

05 .25 05.03.16 8 .11.03 D2807 DRAWING NO GAS NEW ADD FINISH SPRING ISSUE HAWKESBURY, AEROSPACE I SS ADD LTD SHEET á LUG -욱 SCALE

8

 $\omega \mid >$ 

3) ALL DIMENSIONS ARE IN INCHES

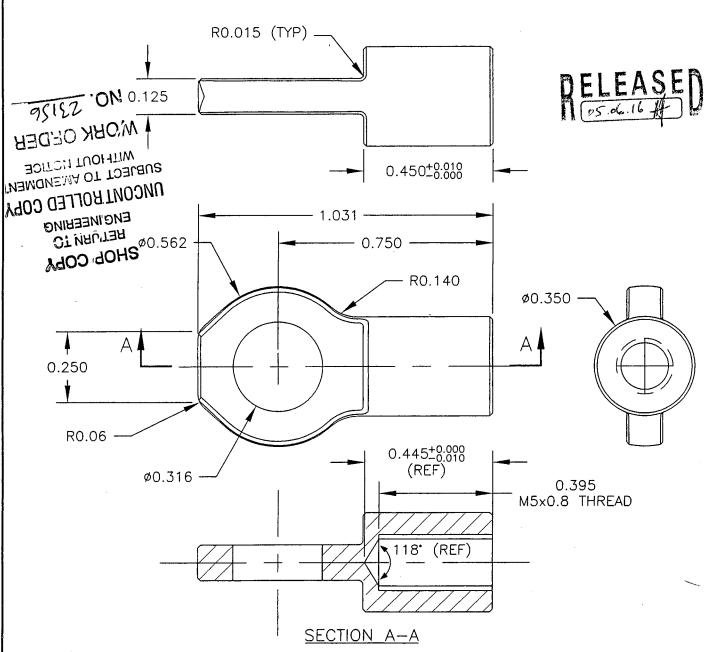
POSSIBLE SUPPLIER:

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

P/N: SXF6S6050080S6L-115N



DESIGN CP	DRAWN BY	_ , , , , , , , , , , , , , , , , , , ,	SPACE LTD INTARIO, CANADA
CHECKED	APPROVED #	DRAWING NO.	REV. C
THE	#	D2807	$_{\mathfrak{G}}$ SHEET 2 OF 2
DATE		TITLE	SCALE
05.05.25		GAS SPRING	3:1



## D2807-3 LUG

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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## Job Costing Report

Dart Aerospace Ltd. Hawkesbury

May 06, 2005 09:55 am

Work Order No : 0023156

Project Name : D2807 Project For : 522

Work Order Type : Main

Main WO Number

House Part Number: D2807 Description : Support Prop

Manufactured : Yes

Amount Req'd: 58

Amount Done : 0 Start Date : 05-04-05

Est Finish Date : 05-31-05

Act Finish Date :

Drawings Reqd : No

Ok for Approval :

Approval Rec'd :

Department Code:

Burden Flags : NNNNNN

WO Status : Open

Invoice State : Not Invoiced

Invoice Date :

Invoice Number :

Invoice Amount: 0.00

Order Entry No :

OE Value : 0.00

Est Mark Up : 0.000% Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

		Estimated	Actual	Var. %	Posted	To Post
Material Cost	:	0.00	0.00	0.00	0.00	0.00
Engineering Hours Engineering Cost	:	0.00 0.00	0.00 0.00	0.00 0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00		
Production Cost	:	0.00	0.00	0.00	0.00	0.00
Packaging Hours Packaging Cost	:	0.00 0.00	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00	0.00	0.00
OverHead Cost	:	0.00	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00		
CNC	:	0.00	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00 0.00	0.00	0.00 0.00	0.00	0.00
Misc.	•	0.00	0.00	0.00	0.00	0.00
Burden	:	0.00	0.00	0.00		
_		========	=======	======		
Total Cost	:	0.00	0.00	0.00		
Mark up	:	0.000	0.000			
Selling Cost	:	0.00	0.00			

Estimated Actual 0.00 Labour Hrs/Amount Done : 0.00 Profits/(Loss) : 0.00 0.00

7 Ls <del>El</del>	FAID PROP	FORMA - C	DART AEROSPA	ACE	17999	AAA
)	1 .		SHIP VIA OUF	R ACCOUNT	200799	STOMER REF. No.
)	<u> </u>				1	RATION No. GB 738 8577 71
		M	1		W ORDER	
)	QTY, ORDERED QTY, O/S XXXXXXX	PART NUMBER	DESCRIPTION	DUE DATE	MLDW7HTTR GTY, ALLOC XXXXXXXXX	ED BATCH No.
)	05/07/19	9XF6050500047 9XF6 96 050 0 80 96 L 32AWS 115N NNN 9P1	. 20mm	20JUN05	161108 2	115
)			!			
)			* * * * * * * * * * * * * * * * * * *			
)						
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`			$\frac{1}{2}$			
)	SPECIAL INSTRUCTION	NS SHIP DATE CARRIER C	CODE WEIGHT DESPATCH	TICKET		
)		27JUN05				Cam 001
)	Arvin Motion Control Limit Main Tel: +44 (0)116 274 36 Sales Tel: +44 (0)116 274 36 Accounts Tel: +44 (0)116 27	Main Fax: +44 (0)116 274 3 622 E-mail - i <u>nfo.amcl@arvinme</u>	3620 eritor.com		TNT GES01697	85 WW
)	have been inspected a	and tested and unless otherwise stated swith the contract/purchase order  SIGNED POSITION	1 6 8 8 8 8 9 8 9 9 9 9 9 9 9 9 9 9 9 9 9			
لبُسسا		DATE	<del></del>			TO THE STATE OF TH

5/22

DART AEROSPACE LTD	Work Order:	23156
Description: Gas Spring	Part Number:	D2807
Dwg: D2807 Rev. B Rev. C. () 65. 07.19	Qty:	23
4 ** 1.11		Page 1 of 1

<u> </u>		Decades	BV	Date	Qty
Step	Location	Procedure \	By	Date	- GIV
1	DC	Issue Traveler	1/	05/05/09	20
		2 1/2667	101	03/03/04	موه
2	PG	Issue P/O: 200 KUT			
		**Note: Do not ship\by air**			
		**Allow an extra 7 to 10 business days for shipping**			_
		Order as per Dwg D280%		1 100	12
		Possible supplier: Spring Lift, P/N SL-4-40 (40 lb load)	IN	03.05.07	
		Material release note is required			
3	RG	Receive and Inspect for transit damage	N /		12/
		Ensure the material release note is attached	いし	05.0509 05.6769	20
4	QC6	Inspect dimensions as per Dwg Dx807 and test spring is 40lb	ľ	1	
5	FP	Open hole as per Dwg D2807 and touch up with paint			
			<u> </u>		
6	FP	Mask, prime and paint as per Dwg D280 using Plasti-Kote "Rust"			
		Not" primer and Plasti-Kote "Super Enamel" T1 Gloss Black		•	
	Ì	Plasti-Kote "Rust Not" Batch:			
		Plasti-Kote "Super Enamel" Batch:	1		
7	QC3	Inspect Paint			
8	PK	Identify and Stock			
	' '`	Tuoritiny aria octobr			
9	AC				
	, .0	Cost / part:			
10	DC	Close W/O			
'`		Inspect Level 21			
		L			

Rev	Date	Change	Revised By	Approved
Α	00.11.09	New Issue	EC\	
В	00.11.15	Added step 6	EC \	2//
С	05.04.28	Reformat; Added Step 6 & 7	KJ/JLM\	

## **Dart Aerospace Ltd**

	WORK ORDER CH					
STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
	STEP					STEP PROCEDURE CHANGE By Date Qty Mfg / Design

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC	Corrective Action Section B			Verification	Annewal	Approval	
		Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector	
						`.			
		•							
						-	į		

Part No:	PAR #:	Fault Category:	NCR:	Yes No	DQA:	Date:
NOTE: Date & initial all entries				QA: N/C C	losed:	Date: